

Date: Monday, 11/21/2005 7:34:54 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RING
 Job Number : 24869
 Estimate Number : 10795
 P.O. Number : N/A Part Number : D34131
 This Issue : 11/21/2005 S.O. No. : N/A Drawing Number : D3413 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : A
 Previous Run : N/A Material : N/A
 Due Date : 11/28/2005 Qty: 20 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE COMMENT BELOW
 Comment : Est Rev:A 05.09.13 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 146

Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3413

Possible Supplier: Industrial Laser

Material release note is required

u 05-11-22

2.0

D34131F

RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

RING

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

DL 05/12/30 22

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

J 01-09

21

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

a.m 06-02-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-01-09	4.1	Smooth and debur laser cut marks as per Dwg D3413 & ASI 018 4.1	EC	06.01.09		EC		
		ADD TO I.P.P. permanent change	DL	06/01/09	22	06.01.09 AB	06.01.09	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 7:34:54 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 24869

Part Number: D34131

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06 02 13

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 78

C 206102113 (22)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUE 06/02/14 (22) 06/02/14 (22)

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

□□□□□□□□

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	:	0024869	Department Code:	
Project Name	:	D3413-1	Burden Flags	: NNNNNNNN
Project For	:	WK550	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3413-1	Invoice Number	:
Description	:	Ring	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	20	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-17-05		
Est Finish Date	:	12-20-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

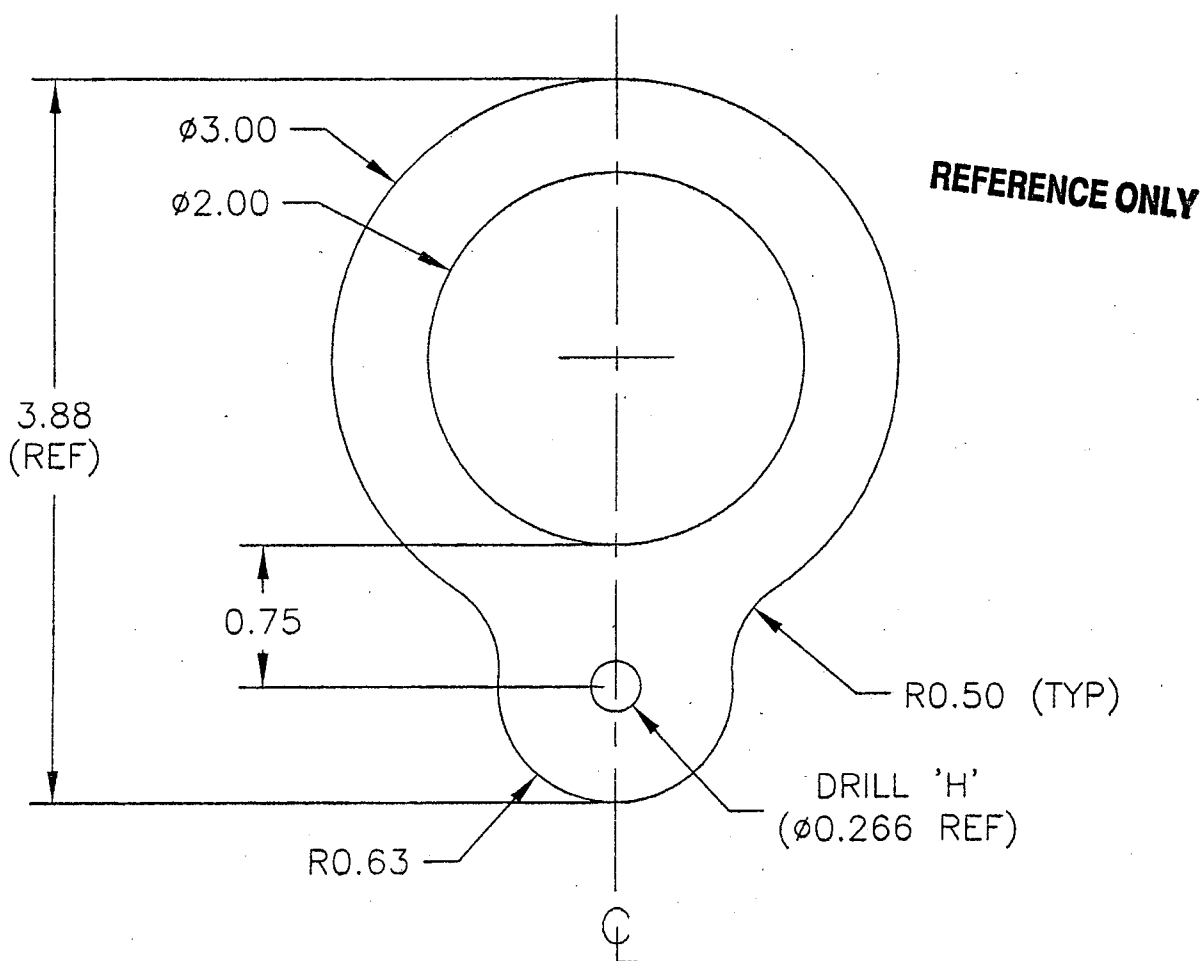


CONTROLLED COPY



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06



D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 2005 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Linda Lacelle

From: Jason Murdoch [jmurdoch@dartaero.com]

Sent: Monday, January 09, 2006 7:00 AM

To: Linda lacelle

Subject: tow ring

Good morning L,


The D3431-1 rings don't have any certs with them. Can I get this this morning pleeeeeeeeeeeeeeease?

Chek ya later.

If you have a list of priorities can you also give me a copy for the week.

jmurdoch@dartaero.com

Q.C.Inspector

7.5
304.250 Kip 

MATERIAL TEST REPORT

From: North American Stainless
6870 Highway 42 East
Ghent , KY410459615

Page : 1
Heat/Lot : 66P3
TIN : B31566

Sold To: INTEGRIS METALS, LTD.
12311 HORSESHOE WAY
RICHMOND , BC V7A 4X6

Ship To: 12311 HORSESHOE WAY
RICHMOND
BCV7A4A5

Vendor Information

Cust PO #: 19087

Cust PO DT: 07/19/05

Specifications

STAINLESS STEEL CONTINUOUS MILL PLATE, HRAP.
ASTMA240/04a, 480/04a, 666/03, ASMESA240/04, SA480/04, SA666/04
QQS766D-A X MGPRM, AMS5511H/AMS5513G XMRK, MIL4043B, AMD3, X CRNMEAS
CORROSION: ASTM A262/02aE; 180Bend-OK
Buyer Part: 75272500
304/304L HRAP .25 IN 48 IN 120 IN
Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O		UOM	L	O
Yield Strength - 0.2% Offset	44.57	KSI	F	TRANSV				
Tensile Strength (UTS)	90.4	KSI	F	TRANSV				
Rockwell B	90		F	TRANSV				
Pct Uniform Elongation 2"/50mm	53.58	PCT	F	TRANSV				
Rockwell B	90		T	TRANSV				

Chemical Composition

C	Carbon-Pct	.020	CR	Chromium-Pct	18.165
CU	Copper-Pct	.347	MN	Manganese-Pct	1.689
MO	Molybdenum-Pct	.303	N	Nitrogen-Pct	.076
NI	Nickel-Pct	8.185	P	Phosphorus-Pct	.030
S	Sulfur-Pct	.000	SI	Silicon-Pct	.350

Comments

200 146

10-01-05
1/4" SS 304

MATERIAL TEST REPORT

From: North American Stainless
6870 Highway 42 East
Ghent , KY410459615

Page : 2
Heat/Lot : 66P3
TIN : B31566

Material free from mercury contamination. No weld repairs.
EN 10204 3.1.B QQS763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 05/03/2005

Jul 01 05

Miscellaneous Data

Control #: 90C47381 Date: 10/19/05
Part #: 75281400
1/4 X GENERAL SIZES

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.